

5/40

87

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24096
<b>Description:</b> Support Assembly	<b>Part Number:</b>	D3278-041
<b>Dwg:</b> D3278 Rev. <i>1307/05.06-07</i>	<b>Qty:</b>	100 <i>98</i>
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler <del>DWG NOT REQUIRED</del> 04.09.05	DL	05.08.23	100																				
2	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) <b>Identify for D3278-1</b>	W17365 Batch: M18375 J.L	05.10.07	100																				
3	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) <b>Identify for D3278-2</b>	Batch: M18745 J.L	05.10.17	110																				
4	MV	Machine D3278-1 as per Folio FA405 and Dwg D3278 <b>Identify as D3278-1</b>	J.L	05.10.12	110																				
5	QC2	Inspect parts as they come off the CNC machine	J.L	05.10.12	110																				
6	MV	Deburr and Tumble	J.L	05.10.12	110																				
7	QC8	Second check	gml	05/10/12	110																				
8	MV	Machine D3278-2 as per Folio FA405 and Dwg D3278 <b>Identify as D3278-2</b>	J.L	05/10/17	100																				
9	QC2	Inspect parts as they come off the CNC machine	J.L	05/10/17	100																				
10	MV	Deburr and Tumble	J.L	05.10.17	100																				
11	QC8	Second check	EP	05/10/17	100																				
12	FP	Acid etch and Alodine as per QSI 005 4.1	SAD	05/11/27	100																				
13	QC5	Inspect work to Step 12	2	05.11.28	110																				
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	ML	05.01.09	110																				
15	QC3	Inspect Powder Coat	DL	06/01/10	110																				
16	GA	Rivet spacers with support as per Dwg D3278. (Note: D3278-1/-2 are on BOM as material from Steps 2-3) <b>Pick: Packing Kit</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3278-1</td><td>Support</td><td>B24096</td></tr><tr><td>1</td><td>D3278-2</td><td>Support</td><td>B24096</td></tr><tr><td>1</td><td>D3278-3</td><td>Spacer</td><td>A24098</td></tr><tr><td>4</td><td>MS20426AD3</td><td>Rivet</td><td>M17694</td></tr></table>	Qty	Part Number	Description	Batch	1	D3278-1	Support	B24096	1	D3278-2	Support	B24096	1	D3278-3	Spacer	A24098	4	MS20426AD3	Rivet	M17694	DL	06/11/11	100
Qty	Part Number	Description	Batch																						
1	D3278-1	Support	B24096																						
1	D3278-2	Support	B24096																						
1	D3278-3	Spacer	A24098																						
4	MS20426AD3	Rivet	M17694																						
17	QC5	Inspect work to Step 16	2	16.04.12	99																				

PTD

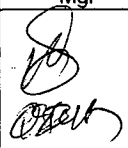
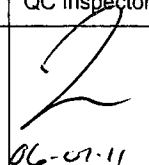

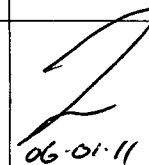
PTD

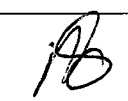
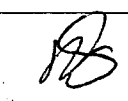


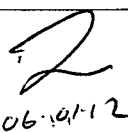
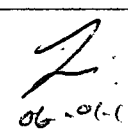
+10

+10

RELEASED

10/04/04-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06/01/10	16	Rivet MS20426 AD 3-7 are Too long need MS 20426 AD 3-6 <del>permanent change</del>	SB	06/01/10			 06-01-11	
06-01-11	16	Stock left over Qty. i Identify D 3278-1 Qty 10					 06-01-11	

NCR: 24096		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.10.12	4	- 10 parts are under tolerance 3278-1 - .119 + .005 - .119 - .004 - spacing between .108 and .113 - are parts acceptable?	CP	PARTS ARE OK. WHEN ASSEMBLING, ENSURE <del>PROPER</del> BOLTS DO NOT BOTTOM OUT.	J.L 05.10.12	 05-10-17	CP 05.10.17 per QSI 042	 05-10-17
05.10.17	8	- 1 part is to thin 3278-2 - lifted in use	AB RETURN	- scrap + replace	J.L 05.10.17	 05-10-17	AB 05-10-17	 05-10-17
06/01/12	16	Stock <del>10 parts of</del> D 3278-1 1x D 3278-2 scrap. Drilled hole oversize when removing a rivet that was no good.	AB RETURN	Stock left over - 1, no more - 2 to complete part.	J.L 06-01-12	 06-01-12	AB 06-01-12	 06-01-12

Part No: D 3278-041

PAR #:

Fault Category:

NCR:

Yes No

DQA:

Date: 06/01/24

NOTE: Date &amp; initial all entries

QA: N/C Closed:

Date: 06/01/24

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24096
<b>Description:</b> Support Assembly		<b>Part Number:</b>	D3278-041
<b>Dwg:</b> D3278 Rev. A <i>15.06.07</i>		<b>Qty:</b>	100
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty																				
18	GA	Assemble support as per Dwg D3278 <b>Pick: Packing Kit</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2230-1</td> <td>Clamp</td> <td>B23724B</td> </tr> <tr> <td>2</td> <td>AN4-13A</td> <td>Bolt</td> <td>M18499</td> </tr> <tr> <td>4</td> <td>AN960JD416</td> <td>Washer</td> <td>M18431</td> </tr> <tr> <td>2</td> <td>MS21042L4</td> <td>Nut (or -4)</td> <td>M17997</td> </tr> </tbody> </table> Identify as D3278-041 <i>Do NOT Tighten Bolts.</i>	Qty	Part Number	Description	Batch	2	D2230-1	Clamp	B23724B	2	AN4-13A	Bolt	M18499	4	AN960JD416	Washer	M18431	2	MS21042L4	Nut (or -4)	M17997	<i>DL</i>	<i>06/01/20</i>	<i>98</i>
Qty	Part Number	Description	Batch																						
2	D2230-1	Clamp	B23724B																						
2	AN4-13A	Bolt	M18499																						
4	AN960JD416	Washer	M18431																						
2	MS21042L4	Nut (or -4)	M17997																						
19	QC5	Inspect work to Step 18	<i>DL</i>	<i>06/01/20</i>	<i>98</i>																				
20	ST	Identify and Stock	<i>SB</i>	<i>06/01/20</i>	<i>98</i>																				
21	AC	Cost / part <i>LDC: 102</i>	<i>CL</i>	<i>06/01/20</i>	<i>98</i>																				
22	DC	Close W/O	<i>Sur</i>	<i>06.01.25</i>	<i>98</i>																				
		Inspect Level 21	<i>D</i>	<i>06/01/21</i>	<i>98</i>																				

Rev	Date	Change	Revised By	Approved
A	04.04.19	New issue	KJ/JLM	<i>11/04.01.22</i>

**RELEASED**

*11/04.01.22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	24096
Description: Support		Part Number:	D3278-1
Inspection Dwg: D3278 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.100	✓			
0.359	+/-0.005	.359	✓			
0.609	+/-0.010	.615	✓			
0.250	+/-0.010	.250	✓			
1.480	+/-0.005	1.478				
R0.125	+/-0.010	.125	✓			
0.119	+0.005/-0.004	.124	✓			
2.439	+/-0.010	2.439	✓			
1.980	+/-0.010	1.985	✓			
R0.130	+/-0.010	.130	✓			
Ø0.257	+0.005/-0.000	.260	✓			
R0.375	+/-0.010	.375	✓			
0.875	+/-0.010	.874	✓			
0.500	+/-0.010	.500	✓			
R0.400	+/-0.010	.400	✓			
1.720	+/-0.010	1.721	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.128	✓			

Measured by: J.L.	Audited by: G	Prototype Approval:	N/A
Date: 05.10.07	Date: 05/10/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	

**RELEASED**  
05.06.07

DART AEROSPACE LTD		Work Order:	24096
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.099	✓			
0.359	+/-0.005	.359	✓			
0.615	+/-0.010	.612	✓			
0.250	+/-0.010	.251	✓			
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	.125	✓			
0.119	+0.005/-0.004	.122	✓			
2.439	+/-0.010	2.440	✓			
1.980	+/-0.010	1.982	✓			
R0.130	+/-0.010	.130	✓			
Ø0.257	+0.005/-0.000	.259	✓			
R0.375	+/-0.010	.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.500	✓			
R0.400	+/-0.010	.400	✓			
1.720	+/-0.010	1.721	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.127	✓			

Measured by: J.L.	Audited by: EP	Prototype Approval:	N/A
Date: 05/10/15	Date: 05/10/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	

RELEASED

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 18, 2005  
10:59 am

Work Order No : 0024096  
Project Name : D3278-041  
Project For : WK540  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3278-041  
Description : Support Assembly  
Manufactured : Yes  
Amount Req'd : 100  
Amount Done : 0  
Start Date : 08-17-05  
Est Finish Date :  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

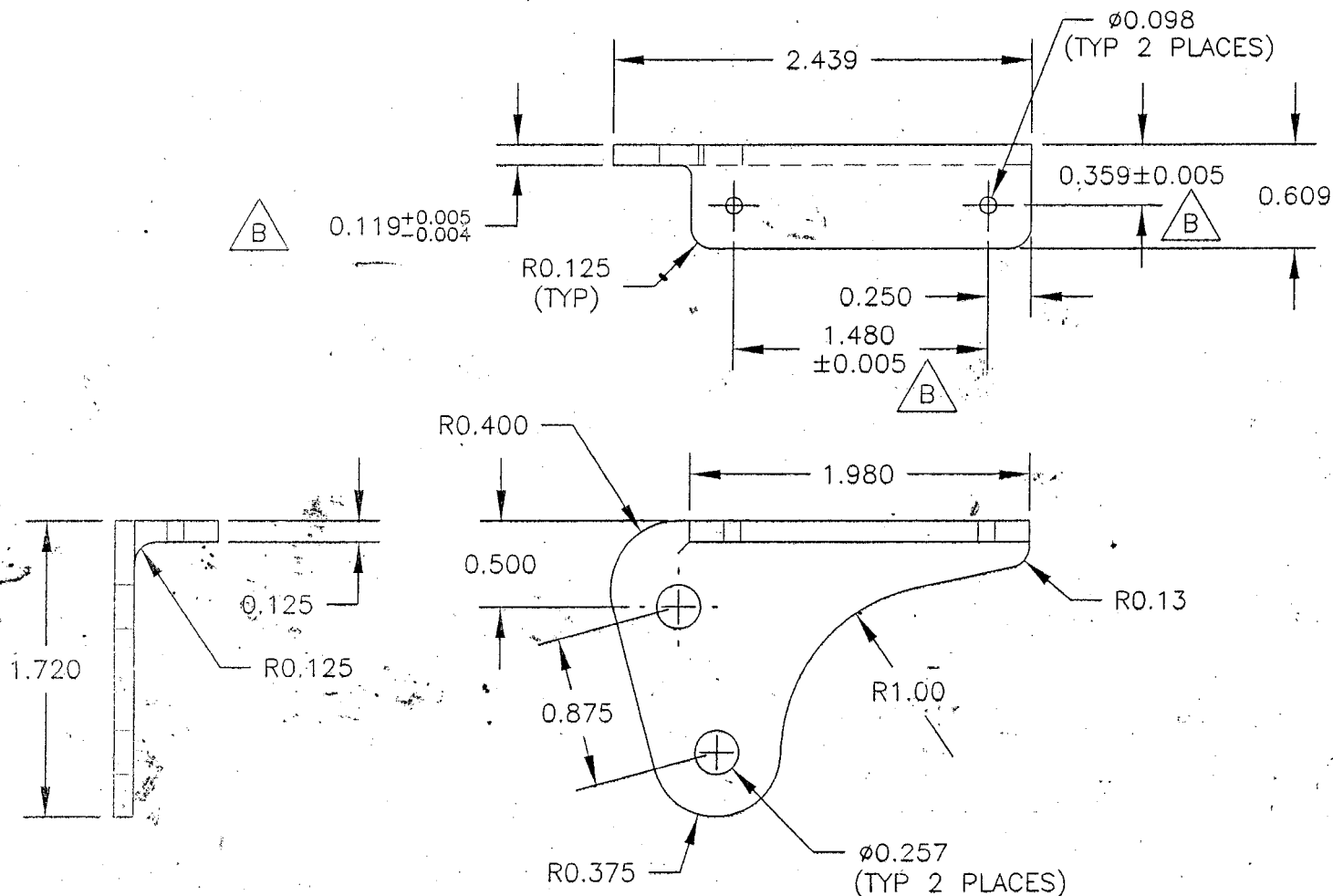


CONTROLLED COPY

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 2 OF 3
DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED

05.04.04 *[Signature]*



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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## Chris Provencal

---

**From:** David Shepherd [davids@dartaero.com]  
**Sent:** October 12, 2005 10:16 PM  
**To:** Chris Provencal  
**Subject:** Re: D3278 problem

Structurally, I don't see a problem with the thin parts. I would double check that the assembly works OK with the plastic spacers and the clamps before signing these parts off.

David

----- Original Message -----

**From:** "Chris Provencal" <cprovencal@dartaero.com>  
**To:** <davids@dartaero.com>  
**Sent:** Wednesday, October 12, 2005 10:42 AM  
**Subject:** D3278 problem

> David,  
>  
> They made (10) D3278-1 brackets (that's the bracket for the fwd 350 step  
> clamp) with a reduced wall thickness. The end of the piece was lifting on  
> the machine, so the wall tapers from nominal down to 0.108" (minimum) at  
> the  
> lower hole. The nominal is 0.119 +0.005 -0.004.  
>  
> They've fixed the problem so this didn't happen on the rest of the batch.  
>  
> Is this acceptable.  
>  
> -Chris  
>  
>  
>

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
10:52 am

Work Order No : 0024096  
Project Name : D3278-041  
Project For : WK540  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3278-041  
Description : Support Assembly  
Manufactured : Yes  
Amount Req'd : 100  
Amount Done : 0  
Start Date : 08-17-05  
Est Finish Date :  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	83.75	100.00		
Production Cost :	0.00	1492.19	100.00	0.00	1492.19
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	83.75	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	1492.19	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	1492.19			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	( -1492.19)

*MUS 01/13*  
*u*  
*11.63*

Date: Monday, 14/11/2005 8:35:35 AM  
 User: Alba Panzuto

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SUPPORT ASSEMBLY
<b>Job Number</b> :	24096		
<b>Estimate Number</b> :	10464		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3278041
<b>This Issue</b> :	14/11/2005	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3278 REV. B
<b>First Issue</b> :	//	<b>Project Number</b> :	
<b>Previous Run</b> :		<b>Drawing Revision</b> :	B
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	30/11/2005
<b>Written By</b> :		<b>Qty:</b>	100
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est:A 04.04.19 New issue KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	24096A	SUPPORT
-----	--------	---------



Comment: Sub-Component SUPPORT

2.0	24096B	SUPPORT
-----	--------	---------



Comment: Sub-Component SUPPORT

3.0	D32781	SUPPORT
-----	--------	---------

4.0	D32782	SUPPORT
-----	--------	---------

5.0	D32783	Spacer
-----	--------	--------

6.0	MS20426AD37	RIVET
-----	-------------	-------

7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Rivet spacers with support as per Dwg D3278.

8.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

9.0	D22301	Mounting Lug
-----	--------	--------------

10.0	AN413A	Bolt
------	--------	------

11.0	AN960JD416	Washer
------	------------	--------

12.0	MS21042L4	Nut
------	-----------	-----

13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Assemble support as per Dwg D3278.  
 \*\*\*DO NOT TIGHTEN BOLTS\*\*\*

Date: Monday, 14/11/2005 8:35:35 AM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 24096

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Identify as D3278-041

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Monday, 14/11/2005 8:35:37 AM  
User: Alba Panzulo

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SUPPORT
<b>Job Number</b> :	24096A		
<b>Estimate Number</b> :	10452		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32781
<b>This Issue</b> :	14/11/2005	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3278 REV. B
<b>First Issue</b> :	/ /	<b>Project Number</b> :	
<b>Previous Run</b> :		<b>Drawing Revision</b> :	B
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	30/11/2005
<b>Written By</b> :		<b>Qty:</b>	100
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est:A 04.04.19 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
-----	--------------------	-------------------------

2.0	SHEAR	SHEAR
-----	-------	-------



**Comment:** SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Date: Monday, 14/11/2005 8:35:37 AM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 24096A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Monday, 14/11/2005 8:35:39 AM  
 User: Alba Panzuto

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SUPPORT
<b>Job Number</b> :	24096B		
<b>Estimate Number</b> :	10462		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32782
<b>This Issue</b> :	14/11/2005	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3278 REV. B
<b>First Issue</b> :	//	<b>Project Number</b> :	
<b>Previous Run</b> :		<b>Drawing Revision</b> :	B
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	30/11/2005
<b>Written By</b> :		<b>Qty:</b>	100
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est:A 04.04.19 New issue KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
-----	--------------------	-------------------------

2.0	SHEAR	SHEAR
-----	-------	-------

**Comment:** SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------

**Comment:** HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Date: Monday, 14/11/2005 8:35:39 AM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 24096B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

